

# Work Order ID 65692

January 21, 2011 2:28:26 PM

Page 1

Item ID: D4306-044

Accept

Revision ID:

Item Name: Rib Assembly, RH

Start Date: 1/21/11

Start Qty: 1.00

Required Date: 1/26/11

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4306

B

100

Weld per dwg A/R S.S. rod Batch: *111585*

0.00

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

*SAD 11-01-25*

*Cpl 11.01.25*

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*Sub 126*

*40*



**Work Order ID 65692**

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Page 2

Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sula 126

①

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

Memo

0.00

SAD  
11-01-26

①

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/27

11-01-26



# Picklist Print

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Page 1

Work Order ID: 65692

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH



Start Date: 1/21/11

Required Date: 1/26/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	63.0000	4	4			
Bushing													

Location Loc Qty Loc Code

WA	63	
54072	9	
64421	12	
64843	42	

M304TS0.750W.049		Purchased	No			100	f	138.7183	4.166	4.385263			
304 SQ Tube .75x.75x.049W													

Location Loc Qty Loc Code

MAT	94.19066794	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	32.7652	
116509	53.2751	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	44.5276	
114992	11.2825	
115260	33.2451	

*CP 11-01-25*

*4*

*SAD 11-01-25*

*4.3853*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

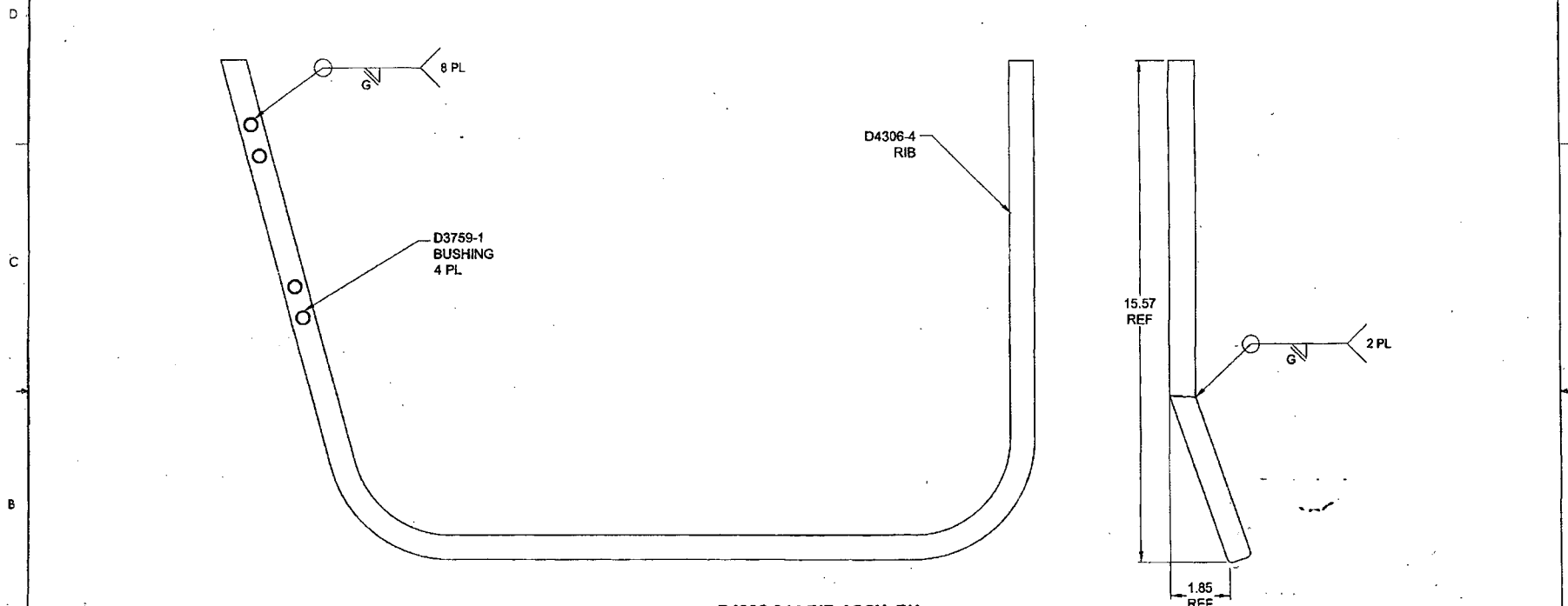
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4306-044 RIB ASSY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

*W/65692*

**RELEASED**  
R 2011-01-18 M

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4306</b>	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB</b>	NTS
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8 7 6 5 4 3 2 1





8 7 6 5 4 3 2 1

D

C

B

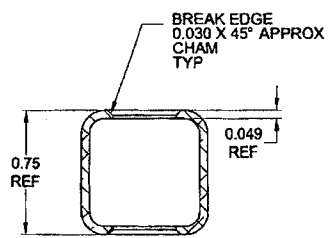
A

D

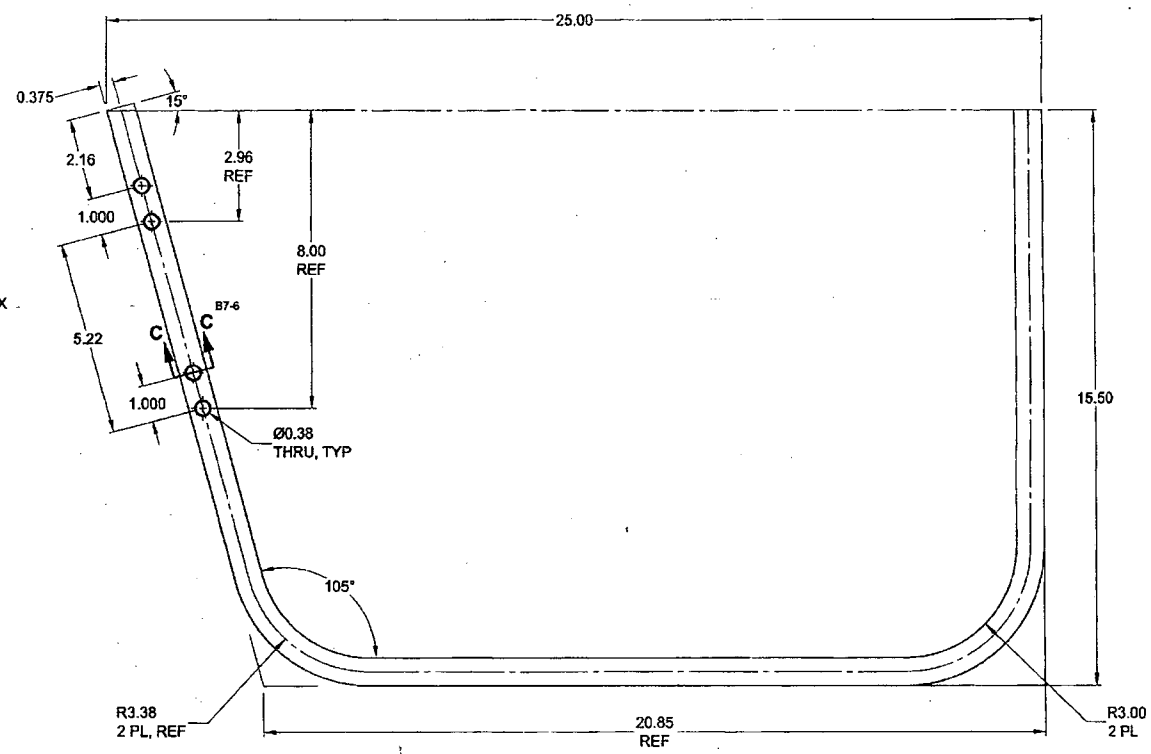
C

B

A



**SECTION C-C**  
C6-6



**D4306-4 RIB**

RELEASED  
2011-01-08  
NM

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.5 REF

65692

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8 7 6 5 4 3 2 1

